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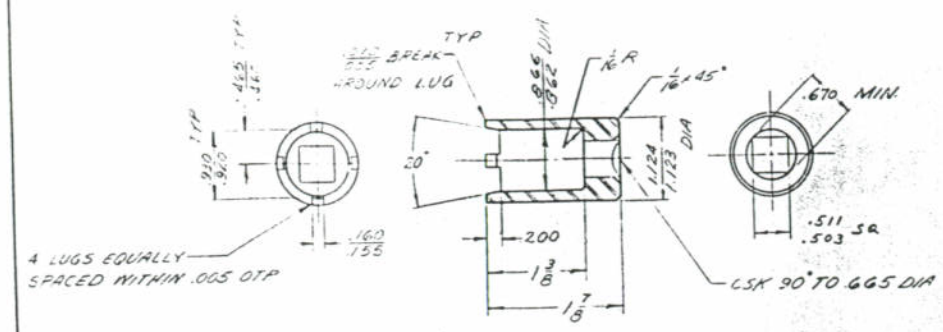
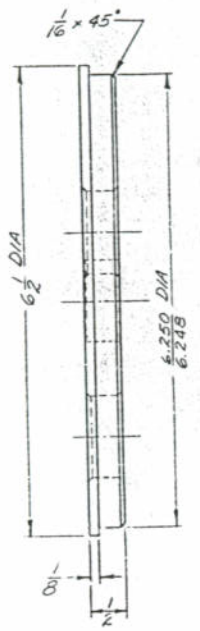
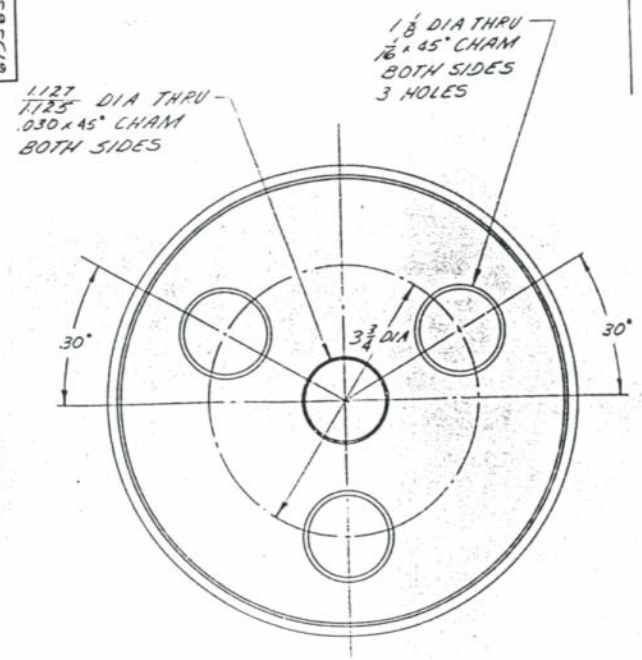
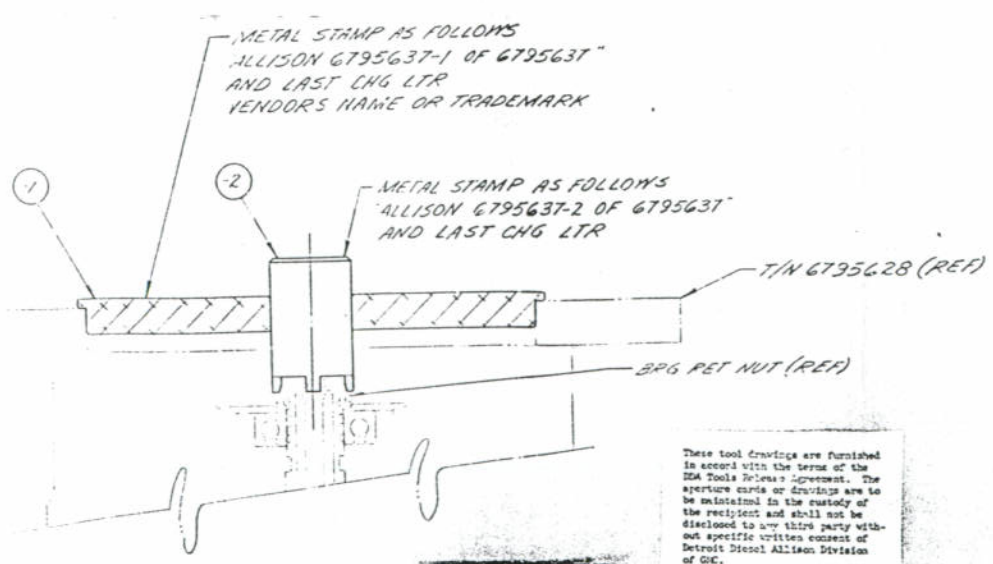


(-2) SAE 4340 HDN 36-40 Rc
1 REQD





(-1) ALUM TYPE 2024-T4
1 REQD



DET NO	SHT NO	MATL	DESCRIPTION	NO REQD
-2	1	SAE 4340	WRENCH	1
-1	1	ALUM	PILOT PLATE	1

6795637
SHT 1 of 1

NOTES:

1. METAL STAMP WITH 1/8 - 3/16 HIGH FIGURES AS SHOWN ON DET-1 & -2 (ASSY VIEW)
2. CADMIUM PLATE DET-2 PER AMS 2400 DIMS MUST BE MET AFTER PLATING
3. ANODIZE DET-1 PER AMS 2470

EACH ITEM PURCHASED SEPARATELY MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DETAIL NUMBER. IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG

AMS 2400
AMS 2470

REVISIONS

LTR	DESCRIPTION	DATE	APPROVAL

REDUCED PRINT

These tool drawings are furnished in accord with the terms of the ERA Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Detroit Diesel Allison Division of GMC.

USED ON ENGINE MODELS
T63-A-5 YT63-A-5, 3, 1

SPECIAL INSPECTION AND TEST REQUIREMENTS

WHEN PART OR ASSEMBLY REQUIRES MAGNETIC AND/OR FLUORESCENT PENETRANT INSPECTION, THESE MUST BE GOVERNMENT-CERTIFIED OPERATORS AND INSPECTORS. WHEN PART OR ASSEMBLY REQUIRES WELDING, OPERATORS AND EQUIPMENT MUST BE GOVERNMENT CERTIFIED. IN ADDITION FACILITIES HAVING GOVERNMENT SOURCE INSPECTION MUST HAVE GOVERNMENT APPROVAL OF X RAY, HEAT TREATMENT, ANODIZING AND PLATING EQUIPMENT WHERE APPLICABLE.

ALL PARTS, OTHER THAN EXPERIMENTAL, MANUFACTURED OR PROCURED TO THIS DRAWING INCLUDING REPLACEMENT SPARES, ARE SUBJECT TO QUALITY CONTROL PER SPECIFICATION MIL-Q-9858 AND USAF SPEC. NOTICES THERETO, AND TO TESTING PER SPECIFICATIONS AND BULLETINS GOVERNING THE QUALIFICATION, APPROVAL AND RELIABILITY OF ALLISON PRODUCTS. MRB PROCEDURES MUST INCLUDE PARTICIPATION BY ALLISON ENGINEERING AND QUALITY CONTROL REPRESENTATIVES UNLESS OTHERWISE AUTHORIZED BY ALLISON.

TOL ON DECIMALS	± .005
TOL ON TWO PLACE DECIMALS	± .010
TOL ON INCH-MILLS DECIMALS	± 1/64
FOUR-PLACE DECIMAL DIMENSIONS WITHOUT TOLERANCES ARE BASIC	SEE DET
HEAT TREAT	SEE DET
WELD OR BRAZE	
SURFACE TREATMENT	NOTED
INSPECTION	

APPROVALS		DATE
DESIGNED	SHAY	6-16-67
CHECKED	RM	6-16-67
CHK. ENG.	DAS	6-16-67
METALLURGIST		
STAGE 1	GH H	6-16-67
STAGE 2	GH	7-6-67
STAGE 3	Dine	7-3-67
STAGE	RH	7-10-68
REVIEW APPROVAL		

ALLISON DIVISION
GENERAL MOTORS CORPORATION
INDIANAPOLIS, INDIANA

TITLE: ADAPTER-INSTALLATION & REMOVAL, GAS PRODUCER TURBINE REAR BRG RETAINING NUT

MODEL

CODE	SIZE	DWG. NO.
73342	D	6795637

SCALE FULL — SHEET 1 OF 1

FILE COPY